

Appl. No. : 09/669,869  
Filed : September 22, 2000

### AMENDMENTS TO THE CLAIMS

Please amend the claims to read as follows. Per practice in reissue applications, amendments are shown relative to the originally-issued claims. Additions are underlined, and deletions are depicted in **[brackets]**. Further, the below listing of claims shows all of the amendments of the claims that have been made during prosecution.

In this action, only Claims 13, 22 and 36 are amended relative to the Amendment filed by Applicants on September 7, 2004.

1. (Previously Presented) An integrally formed roller skate chassis adapted for attachment of a plurality of skate wheels, said chassis comprising:

a heel attachment member and a forefoot attachment member for attaching said chassis to a skating boot; and

a pair of laterally spaced first and second longitudinal members, said longitudinal members having generally planar upper portions with upper edges integrally attached to said heel and forefoot attachment members and lower portions for accommodating attachment of a wheel set, one of said upper portions of the first longitudinal member being substantially coplanar with a respective lower portion, **[the other]** one of said upper portions of the second longitudinal member being inclined toward the coplanar one of said upper portions in an upwardly extending direction, said lower portions **[in an upwardly extending direction]** being substantially parallel to each other, and one or more connecting webs extending between said longitudinal members and integrally attached to said longitudinal members where said upper and lower portions intersect;

wherein said chassis has enhanced structural integrity for a given weight of material.

2. (Original) The chassis of Claim 1, wherein said lower portions have one or more horizontally elongated openings formed therein to reduce weight and excess material.

3. (Original) The chassis of Claim 1, wherein said lower portions have one or more ribs formed thereon.

4. (Original) The chassis of Claim 1, wherein said connecting webs have one or more chamfered edges adjacent to said skate wheels so as to accommodate closer spacing between said skate wheels.

5. (Previously Presented) An integrally formed roller skate **[stake]** chassis, adapted for attachment of a plurality of skate wheels, said chassis comprising:

a heel attachment member and a forefoot attachment member for attaching said chassis to a skating boot; and

a pair of laterally spaced longitudinal members having upper edges integrally attached to said heel and forefoot members, said longitudinal members having upper and lower generally planar portions separated by one or more web members extending between said longitudinal members and attached thereto, said upper portions forming substantially convergent planes in an upwardly extending direction above said one or more web members**[member]**, said lower portions forming substantially parallel planes below said one or more web members, such that said chassis forms substantially an A-frame when viewed in cross section;

wherein said chassis has enhanced structural integrity and more efficient transfer of power from a skater to said skate wheels during use.

6. (Original) The chassis of Claim 5, wherein said one or more web members are spaced to form a plurality of openings for accommodating said wheels.

7. (Original) The chassis of Claim 5, wherein said chassis has an extruded unibody construction.

8. (Original) The chassis of Claim 7, wherein said chassis is formed from an extruded aluminum billet which is machined to the desired shape.

9. (Original) The chassis of Claim 5, wherein said chassis has flush-mounted, rockerable axle holes.

10. (Original) The chassis of Claim 5, wherein said lower portions have at least one horizontally elongated opening formed therein to reduce weight and excess material.

11. (Original) The chassis of Claim 5, wherein said lower portions have at least one rib formed thereon.

12. (Original) The chassis of Claim 5, wherein said web members have at least one chamfered edge adjacent to said skate wheels so as to accommodate closer spacing between said skate wheels.

13. (Currently Amended) A roller skate chassis assembly interconnected as a unit for attachment to a skate boot, the chassis assembly comprising:

a forefoot section and a heel section;

a pair of laterally spaced longitudinal support members spanning the forefoot and heel sections of the chassis, each support member having a substantially planar lower portion, the lower portions being parallel to each other and adapted to receive a plurality of skate wheels therebetween;

one or more web members extending between and attached to the lower portions of the support members, the web member positioned so as to be between successive wheels;

an upper portion in the forefoot section of each support member, the upper portion extending upwardly from the lower portion and having an upper edge, and a mounting flange extends from each upper edge, the mounting flange having at least one mount hole;  
and

an upper portion in the heel section of each support member, the upper portion extending upwardly from the lower portion and having an upper edge, and a mounting flange extends from each upper edge, the mounting flange having at least one mount hole;

wherein in at least one of the heel and forefoot sections, the upper portions lie in substantially convergent planes in an upwardly extending direction above said one or more web members.

14. Cancelled

15. Cancelled

16. (Previously Presented) The chassis of Claim 13, wherein the chassis has an extruded unibody construction.

17. (Previously Presented) The chassis of Claim 13, wherein the support members are formed separately from one another.

18. (Previously Presented) The chassis of Claim 13, wherein each mounting flange extends from its respective upper edge in a direction away from the upper portions.

19. (Previously Presented) The chassis of Claim 13, wherein the upper portions in the heel section of the chassis lie in substantially convergent planes in an upwardly extending direction.

20. (Previously Presented) The chassis of Claim 13, wherein the upper portions in the forefoot section of the chassis lie in substantially convergent planes in an upwardly extending direction.

21. (Previously Presented) The chassis assembly of Claim 17, wherein the support members and one or more web member are integrally attached to one another.

22. (Currently Amended) A roller skate chassis assembly integrated as a unit for attachment of a plurality of skate wheels, said chassis assembly comprising:

an elongate left chassis member and an elongate right chassis member, each chassis member having a front region, a back region, and a substantially planar lower portion extending through the front and back regions, the left and right chassis members being spaced apart from each other and arranged so that the left and right lower portions lie in substantially parallel planes, the lower portions being adapted so that a plurality of skate wheels are supported therebetween;

one or more web members extending between the left and right chassis members and adapted so that the chassis members and one or more web members are integrally attached to one another;

each chassis member having a substantially planar upper portion in the front region and a substantially planar upper portion in the back region, the upper portions being positioned substantially above the one or more web members;

a forefoot mount defined above and being supportingly connected to the front upper portions in the front regions of the left and right chassis members, the forefoot mount being adapted to accomodate attachment of a forefoot portion of a skate boot sole;  
and

a heel mount defined above and being supportingly connected to the back upper portions in the back regions of the left and right chassis members, the heel mount being adapted to accomodate attachment of a heel portion of a skate boot sole;

wherein at least one of the upper portions of each of the chassis members lies in a plane that is inclined relative to the adjacent planar lower portion and is convergent in an upward direction with the corresponding planar upper portion of the spaced apart chassis member.

23. (Previously Presented) The chassis assembly of Claim 22, wherein the upper portions in the back regions of each of the left and right chassis members lie in planes that are inclined relative to their corresponding lower portions, such that said chassis assembly forms substantially an A-frame when viewed in cross section at the back regions of the chassis members.

24. (Previously Presented) The chassis assembly of Claim 22, wherein the upper portions in the front regions of each of the left and right chassis members lie in planes that are inclined relative to their corresponding lower portions, such that said chassis assembly forms substantially an A-frame when viewed in cross section at the front regions of the chassis members.

25. (Previously Presented) The chassis assembly of Claim 22, wherein the chassis assembly has unitary, extruded construction.

26. (Previously Presented) The chassis assembly of Claim 22, wherein the left chassis member, right chassis member and one or more web member are formed separately from one another.

27. (Previously Presented) The chassis assembly of Claim 26, wherein the chassis members are welded to the one or more web member.

28. (Previously Presented) The chassis assembly of Claim 22, wherein at least one of the upper portions of each of the chassis members lies in a plane that is inclined between about 60° - 88° relative to the plane of the lower portion.

29. (Previously Presented) A method of making a roller skate chassis, comprising:  
forming an elongate left chassis member and an elongate right chassis member,  
each chassis member having a front region, a back region, a substantially planar lower

portion extending through the front and back regions, a substantially planar upper portion in the front region, and a substantially planar upper portion in the back region, at least one of the upper portions of each chassis member being angled relative to the respective lower portion, a forefoot mount portion defined above the front upper portions of the left and right chassis members, each forefoot mount being adapted to accomodate attachment of a forefoot portion of a skate boot sole, and a heel mount portion defined above the back upper portions of the left and right chassis members, each heel mount being adapted to accomodate attachment of a heel portion of a skate boot sole;

forming at least one cross member; and

arranging the at least one cross member between the left and right chassis members so that the at least one cross member extends between the left and right chassis members, the chassis members are spaced apart from one another, the upper portions of the chassis members are positioned substantially above the at least one cross member, and at least one of the upper portions of each of the chassis members lies in a plane that is inclined relative to the adjacent planar lower portion and is convergent in an upward direction with the corresponding planar upper portion of the spaced apart chassis member.

30. (Previously Presented) The method of Claim 29, wherein the left chassis member, right chassis member and cross member are formed separately.

31. (Previously Presented) The method of Claim 30, wherein the left and right chassis members are welded to the cross member.

32. (Previously Presented) The method of Claim 29, wherein forming comprises extruding a billet of material and machining the extruded billet.

33. (Previously Presented) The method of Claim 32, wherein the chassis has a unibody construction.

34. (Previously Presented) The method of Claim 29, wherein the upper portions in the back regions of each of the left and right chassis members lie in planes that are inclined relative to their corresponding lower portions, such that said chassis forms substantially an A-frame when viewed in cross section at the back regions of the chassis members.

35. (Previously Presented) The method of Claim 29, wherein the upper portions in the front regions of each of the left and right chassis members lie in planes that are inclined

relative to their corresponding lower portions, such that said chassis forms substantially an A-frame when viewed in cross section at the front regions of the chassis members.

36. (Currently Amended) A roller skate chassis assembly interconnected as a unit for attachment to a skate boot, the chassis assembly comprising:

a forefoot section and a heel section;

a pair of laterally spaced support members spanning the forefoot and heel sections of the chassis, each support member having a substantially planar lower portion, the lower portions being parallel to each other and adapted to receive a plurality of skate wheels therebetween;

at least one web member extending between and attached to the support members, the at least one web member positioned so as to be between successive wheels;

an upper portion in the forefoot section of each support member, the upper portion extending upwardly from the lower portion and having an upper edge, and a mounting flange extending from each upper edge, the mounting flange having at least one mount hole; and

an upper portion in the heel section of each support member, at least part of each upper portion lying in a plane that is inclined relative to the lower portion, the upper portion planes being convergent in an upwardly direction above the at least one web member, the upper portion extending upwardly from the lower portion and having an upper edge, and a mounting flange extending from each upper edge, the mounting flange having at least one mount hole;

wherein in at least one of the heel and forefoot sections, the upper portions are spaced such that a distance between the upper portions is less than a distance between the planar lower portions.

37. (Previously Presented) The assembly of Claim 36, wherein in at least one of the heel and forefoot sections, the upper portions are generally inwardly inclined above said one or more web members.

38. (Previously Presented) The assembly of Claim 36, wherein in at least one of the heel and forefoot sections, a distance between the upper portions at their respective upper edges is less than a distance between the support members at or adjacent the at least one web member.

39. (Previously Presented) The assembly of Claim 36, wherein a line extending between the upper edge of a support member and the intersection of the support member and a web member is angled between about 60-88 degrees relative to horizontal.

40. (Previously Presented) The assembly of Claim 36, wherein at least one of the upper portions is curved.

41. (Previously Presented) The assembly of Claim 36, wherein the upper portions are substantially planar.

42. (Previously Presented) The assembly of Claim 36, wherein the support members are formed separately from one another.

43. (Previously Presented) The assembly of Claim 42, wherein the support members and one or more web members are integrally attached to one another.

44. (Previously Presented) The assembly of Claim 36, wherein the chassis has an extruded unibody construction.

45. (Previously Presented) The assembly of Claim 36, wherein in at least one of the heel and forefoot sections, the support members and at least one web member generally form an "A" shape when viewed in cross section.

46. (Previously Presented) A method of making a roller skate chassis, comprising:  
forming an elongate left chassis member and an elongate right chassis member,  
each chassis member having a front region, a back region, a substantially planar lower  
portion extending through the front and back regions, an upper portion in the front region,  
and an upper portion in the back region, at least a portion of at least one of the upper  
portions being inclined relative to the corresponding lower portion, an upper edge of each  
front upper portion attached to a front mount portion, the front mount portion being  
adapted to accommodate attachment of a forefoot portion of a skate boot sole, an upper  
edge of each back upper portion attached to a back mount portion, the back mount portion  
being adapted to accommodate attachment of a heel portion of a skate boot sole;

forming at least one cross member; and

arranging the at least one cross member between the left and right chassis  
members so that the at least one cross member extends between the left and right chassis  
members and has a length, and the upper edges of the front and back upper portions are



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disposed vertically higher than the at least one cross member, and a distance between the upper edges in at least one of the front and back upper portions is less than the length of the cross member.

47. (Previously Presented) The method of Claim 46 additionally comprising forming at least one mount hole in each of the front and back mount portions.

48. (Previously Presented) The method of Claim 46, wherein the left chassis member, right chassis member and cross member are formed separately.

49. (Previously Presented) The method of Claim 48, wherein the left and right chassis members are welded to the cross member.

50. (Previously Presented) The method of Claim 46, wherein forming comprises extruding a billet of material and machining the extruded billet.

51. (Previously Presented) The method of Claim 50, wherein the chassis has a unibody construction.

52. (Previously Presented) The method of Claim 46, wherein at least one of the upper portions is curved.

53. (Previously Presented) The method of Claim 46, wherein the upper portions are substantially planar.